

Date: Monday, 05/03/2007 11:52:41 AM
User: Linda Lacelle

Process Sheet

SPLIT

100 16 MAY

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 30996	Part Number	: D32351
Estimate Number	: 10428	Drawing Number	: D3235 REV A
P.O. Number	: <i>PLA</i>	Project Number	: N/A
This Issue	: 05/03/2007 S.O. No. : <i>PLA</i>	Drawing Revision	: A
Prsht Rev.	: NC	Material	: <i>PLA</i>
First Issue	: 01/03/2007 Type : MACHINED PARTS	Due Date	: 03/12/2007
Previous Run	: 30050	Qty:	500 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est A 04.04.19 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 35.8575 f(s)
Lug Extrusion
D2423 extrusion
Batch: *30062*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: Band Saw
Cut D2423 extrusion to 0.820"
Batch: *N/A ↑*

Metec

3.0	PG	PURCHASING
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Comment: PURCHASING
Issue P/O *BLKT 00001*
Possible Supplier : Metec
Machine per Drwg D3235 Rev.A

C207/03/08 (500)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect for transit damage

2/15/16 (100)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

AC517 (100) (100) (100)
per ASP 019

Date: Monday, 05/03/2007 11:52:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30996

Part Number: D32351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fd 07/05/22 (100)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT WORK TO CURRENT STEP

mk 07/05/23 (100K)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

HD 07-05-24 (100)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/05/25 (100)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *4410*

EP 07/05/25 (100)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

100 07/05/28

Job Completion



u 07/05/28

Date: Thursday, 3/1/2007 11:34:08 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 30996		
Estimate Number	: 10428		
P.O. Number	:	Part Number	: D32351
This Issue	: 3/1/2007 S.O. No. :	Drawing Number	: D3235 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 30050	Material	:
Written By	:	Due Date	: 12/3/2007 Qty: 500 Um: Each
Checked & Approved By	: <u>07.03.01</u>		
Comment	: Est A 04.04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
-----	-------	---------------



Comment: Qty.: 0.0717 f(s)/Unit Total : 35.8575 f(s)
 Lug Extrusion
 D2423 extrusion
 Batch: _____

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: Band Saw
 Cut D2423 extrusion to 0.820"
 Batch: _____

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA369 and Dwg D3235
 2-Identify as D3235-1
 3-Deburr and Tumble

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/1/2007 11:34:08 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30996

Part Number: D32351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: RD Date: 27/05/20
 QA: N/C Closed: _____ Date: _____

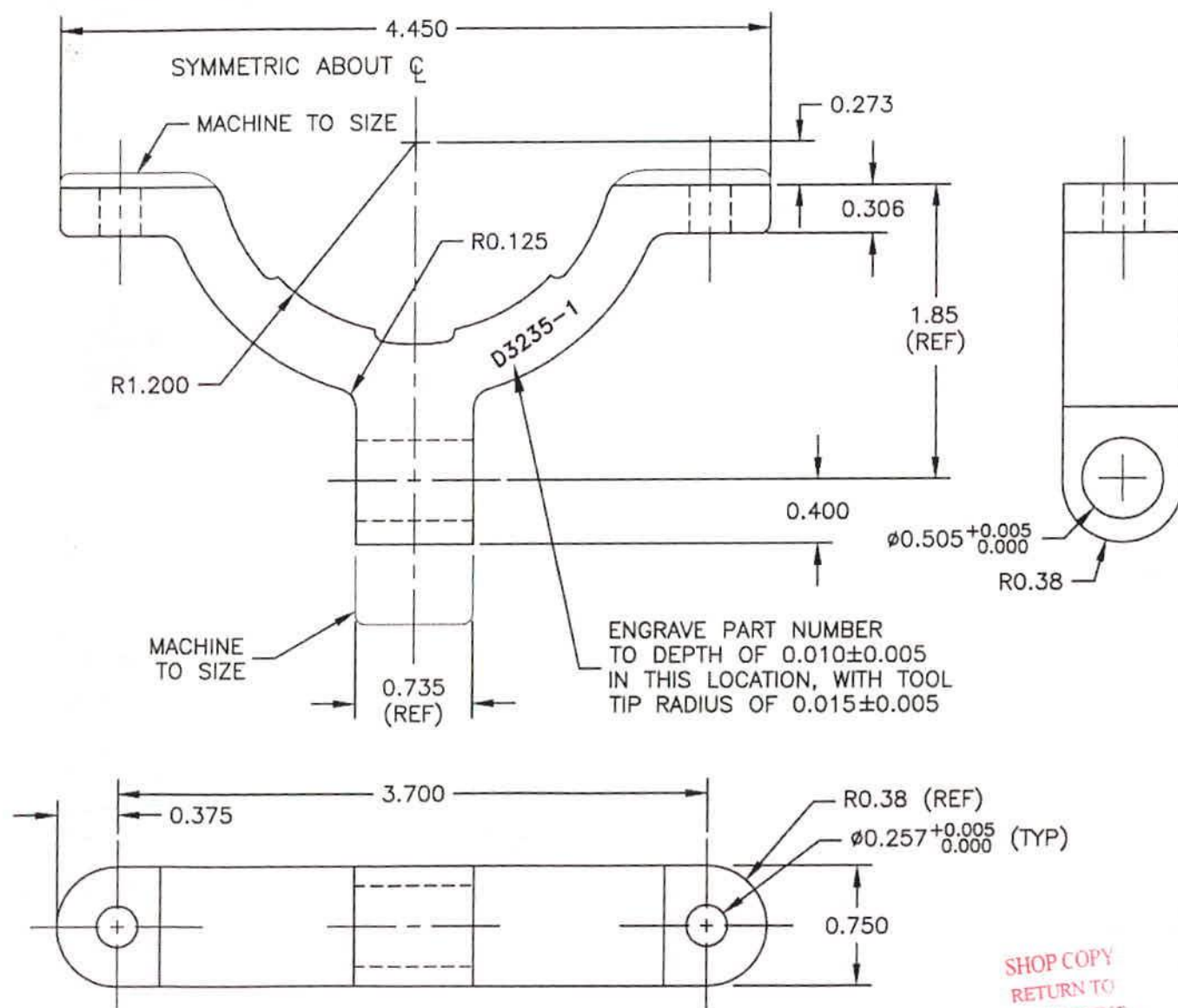
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30996

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

100 ✓

PART NUMBER

D3235-1 ✓

PART NAME

Lug B30996

P.O. NUMBER

BLKT00001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, May 16, 2007

